



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3560-3
Job Sheet 175952



Part No: D3560-3

Job Qty: 4 ea

Part Name: Arm



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/12/18

Job Tracking No:

Due Date: 6/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:A New Issue 06-11-10 JLM use-043 IPP REV:B 13.06.03 PER DWG REV.F DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		5/19/18	0.00	0.00	Start Up Machining-2		SC
100	Bandsaw	4 pcs		5/19/18	0.00	0.00	Bandsaw1		SC
110	CNC Vertical Machining	4 pcs		5/19/18	0.49	2.99	HAAS1-4		SC
120	QC	4 pcs		5/19/18	0.00	0.00	QC2 Machining-2		SC
124	Mill Conv	4 pcs		5/21/18	0.00	0.35	Mill Conv 1		SBL
126	QC	4 pcs		5/21/18	0.00	0.00	QC2 Machining-2		SBL
130	QC	4 pcs		5/21/18	0.00	0.00	QC8 Machining-2		SC
210	Packaging	4 pcs		5/21/18	0.00	0.00	Packaging3-1		SC
220	QC21-SA	4 Ea		5/21/18	0.00	0.00	QC21		SC

Part Op 100 - Cut blanks 15.500" long
Descriptions: 110 - 1- Mill as per Folio FA695 Rev: _____ & Dwg D3560 Rev: _____
210 - LOCATION: WA003
220 - 2-Deburr per dwg D3560

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X05.000	6061-T6 Bar .500 X 5.00	5.5600 ft (1.39 ea)	90-Start up Operation	5047294

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.500X05.000	6	60	0

Part Spec

Spec No	Description	Target/Tolerance
1	Arm	0.507Inches + 0.000 - 0.001
2	Arm	0.196Inches + 0.005 - 0.001
3	Arm	1.000Inches + 0.010 - 0.001
4	Arm	0.900Inches + 0.010 - 0.001



Container No: S090240



Part: D3560-3

Job No: 175952

Serial No/Batch: S090240

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/10/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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5	Arm	0.500Inches $\pm$ 0.010	0.510 0.490	
6	Arm	0.250Inches $\pm$ 0.010	0.260 0.240	
7	Arm	0.275Inches $\pm$ 0.010	0.285 0.265	
8	Arm	0.188Inches $\pm$ 0.010	0.198 0.178	
9	Arm	1.750Inches $\pm$ 0.010	1.760 1.740	
10	Arm	1.702Inches $\pm$ 0.010	1.712 1.692	
11	Arm	0.385Inches $\pm$ 0.010	0.395 0.375	Diameter
12	Arm	100.000Degrees $\pm$ 0.500	100.500 99.500	Angle
13	Arm	0.250Inches $\pm$ 0.010	0.260 0.240	Depth

Plex 4/12/18 12:50 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
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	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment	☐	No Re-verification	☐	Pressure/Forced	☐
Design	☐	Operator	☐	Bending	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐
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Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐
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